



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9910
Job Sheet 204977



Part No: 646.9910

Job Qty: 40 pcs

Part Name: Struts



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: Stock *Scrap*

Description:

Note: 646.9900 rev nc1 IPP REV:A NEW ISSUE 12-09-19 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
110	Doosan - 1	40 pcs	2/14/20	2/14/20	0.00	7.86	Doosan - 1	<i>De</i>
120	QC 2	40 pcs	2/14/20	2/14/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
170	QC 8	40 pcs	2/14/20	2/14/20	0.00	0.00	QC 8 - 12	



Container No: S247268



Part: 646.9910

Job No: 204977

Serial No/Batch: S247268

Revision: nc1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/14/20

					QC 8 - 14		MD 2020/01/20
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8		
					QC 8 - 9		
					QC 8 - 68		
					QC 8 - 67		
					QC 8 - 1 (A)		
					QC 8 - 47		
					QC 8 - 40		
					QC 8 - 76		
180	Outsource - 4 - Anodize	40 pcs	2/14/20		ATG001-VC	8	2020-01-20
190	Packaging 2-1 - Receive - B4B	40 pcs	2/14/20	0.00 0.00	Packaging 2 - 1 - B4B		
					Packaging 2 - 2 - B4B		
					Packaging 2 - 3 - B4B		
					Packaging 2 - 5 - B4B		JAN 28 2020
					Packaging 2 - 4 - B4B		
					Packaging 2 - 6 - B4B		
					Packaging 2 - 7 - B4B		
					Packaging 2 - 8 - B4B		
					Packaging 2 - 9 - B4B		
					Packaging 2 - 10 - B4B		
					Packaging 2 - 11 - B4B		
					Packaging 2 - 12 - B4B		
					Packaging 2 - 13 - B4B		
					Packaging 2 - 14 - B4B		
					Packaging 2 - 15 - B4B		
					Packaging 2 - 16 - B4B		
					Packaging 2 - 17 - B4B		
					Packaging 2 - 18 - B4B		
					Packaging 2 - 19 - B4B		
					Packaging 2 - 20 - B4B		
					Packaging 2 - 21 - B4B		
					Packaging 2 - 22 - B4B		
					Packaging 2 - 23 - B4B		
					Packaging 2 - 24 - B4B		
					Packaging 2 - 25 - B4B		
					Packaging 2 - 26 - B4B		
					Packaging 2 - 27 - B4B		
					Packaging 2 - 28 - B4B		
					Packaging 2 - 29 - B4B		
					Packaging 2 - 30 - B4B		
					Packaging 2 - 31 - B4B		
					Packaging 2 - 32 - B4B		
					Packaging 2 - 33 - B4B		
					Packaging 2 - 34 - B4B		
					Packaging 2 - 35 - B4B		
					Packaging 2 - 36 - B4B		

200 QC 6	40 pcs	2/14/20	0.00 0.00	QC 6 - 9	FEB 05 2020	DAS 68 9-89
				QC 6 - 68		
				QC 6 - 61		
210 Packaging 3-1 - Stock - B4B	40 pcs	2/14/20	0.00 0.00	Packaging 3 - 1 - B4B	FEB 06 2020	DAS 74 9-89
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
220 QC 21 - SA	40 pcs	2/14/20	0.00 0.00	QC 21 - SA - 21	FEB 06 2020	DAS 21 9-89
				QC 21 - SA - 70		
				QC 21 - SA - 53		

Part Op 110 - *** CUT BLANK ON CHOP SAW AT 24.030" LONG*** TURN AS PER DWG DWG REV: A FOLIO
 Descriptions: REV: NA DEBURR

120 - QC2- Inspect parts off machine FAI/FAIB

170 - QC8- Inspect parts - second check

180 - Issue P/O to ATG : 45630 Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C

190 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached

200 - (QC6- All purchased or subcontracted products)

210 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.563	6061-T6 Round Bar .563	84 ft (2.1 ea)	110-Doosan - 1	5236287

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Doosan - 1	M6061T6R0.563	84	115	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	0.563Inches $\pm$ 0.010	0.573 0.553	0.567	
2	Strut	0.190Inches $\pm$ 0.010	0.200 0.180	0.190	
3	Strut	0.275Inches $\pm$ 0.010	0.285 0.265	0.275	
4	Strut	24.000Inches $\pm$ 0.030	24.030 23.970	24"	
5	Strut	0.201Inches + 0.005 - 0.001	0.206 0.200	.203	
6	Strut	45.0Angle $\pm$ 0.5	45.5 44.5	45	

Plex 12/23/19 2:14 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		FAULT CATEGORY Other/Details: _____			



Dart Aerospace Ltd.
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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

POHB045630



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045630

PO Date: 1/20/20

Due Date: 2/7/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-01-28

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204587	D4970-3	D4970 Rev C	Windshield Deflector - Upper : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg D4970 Rev. C	Firmed	-	2/7/20	4 pcs	0 pcs	4 pcs	\$35.93/pcs	\$143.72
2	203836	647.3910	647.3900 Rev C2	412 Upper Deflector : Various STC's Issue P/O to ATG : 1- Black Anodize as per Dwg 647.3900 2- PRIME AS PER DWG, SEE NOTE #9	Firmed	-	2/7/20	11 pcs	0 pcs	11 pcs	\$13.23/pcs	\$145.53
3	204977	646.9910	646.9900 Rev nc1	Struts Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	-	2/3/20	40 pcs	0 pcs	40 pcs	\$14.58/pcs	\$583.20

JAN 28 2020

JAN 28 2020

Line Item Note **see need by date**



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PURCHASE ORDER

POHB045630



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	204279	RBEL131M-0002-101-03	RBEL131M-0002-101 Rev 2	Hinge -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed x4	-	2/7/20	4 pcs	0 pcs	4 pcs	\$7.18/pcs	\$28.72
JAN 28 2020												
5	204026	D5631-1	D5631 Rev B	Spacer : Various STC's Issue P/O: ANODIZE COLOR BLACK, PER MIL-A-8625 TYPE 2 CLASS 2 PRIME AS PER MIL-PRF- 23377, QSI005 4.2.1.3.2 Certification of Conformity is required	Firmed x30	-	2/7/20	30 pcs	0 pcs	30 pcs	\$4.53/pcs	\$135.90
JAN 29 2020												
6	205003	647.2114	647.2100 Rev E	Upper U Channel : Various STC's Issue P/O to ATG : 1- Anodize as per MPP-172 sect. 2.1 2- Pretreatment as per MPP-172 sect. 3.3 3-Prime as per MPP-172 sect. 4.3 As Per Dwg 647.2100 Rev. E	Firmed x16	-	2/7/20	16 pcs	0 pcs	16 pcs	\$12.43/pcs	\$198.88
Grand Total:												\$1,235.95

Sherrin



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PURCHASE ORDER
POHB045630



Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/28/20 9:55 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919456

Date: 24-Jan-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 11 ea	Part: 647.3910 Upper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-P-23377J, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing Batch/Lot#: 128522 Job: 26789 PO: POHB045630	Rev: C2 Expiry Date: 05/21 Line: 2	
✓ 40 ea	Part: 646.9910 Struts Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 128522 Job: 26790 PO: POHB045630	Rev: NC Expiry Date: 05/21 Line: 3	 DAS 68 9-89
✓ 30 ea	Part: D5631-1 Spacer Hard Black Anodize per MIL-A-8625F, Type II, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 128522 Job: 26792 PO: POHB045630	Rev: B Expiry Date: 05/21 Line: 5	 RECEIVED JAN 27 2020 DART AEROSPACE LTD.
Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919456

Date: 24-Jan-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery
Quantity	Description
✓ 16 ea	Part: 647.2114 Upper U Channel Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-P-23377J, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing Rev: E Batch/Lot#: 128522 Job: 26793 PO: POHB045630 Expiry Date: 05/21 Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JAN 24 2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.	